

Customer : CU-DAR001 Part Helicopters Services Drawing Name : DDOUBLER
Job Number : 31828
Estimate Number : 11592
P.O. Number : N/A Part Number : D2911
This Issue : 4/17/2007 S.O. No. : N/A Drawing Number : D2911 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
Previous Run : N/A Material : N/A
Written By : Due Date : 4/24/2007 Qty: 20 Um: Each
Checked & Approved By : JLM 07.04.17
Comment : Est B 02.11.12 Re-format; Incorporated D2911 and D2912 K
J
Est Rev:C Now on Waterjet 07-01-23 JLM

Job Number:



1.0 M6061T6S090 6061-T6 .090 Sheet



6061-T6 .090 Sheet

Batch: MA295

ml 07 04 18

20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



1-Cut as per Dwg D2911

Dwg Rev: A

Prog Rev: A

07 04 18

20

2-Deburr if necessary

813 07604/19 to

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



07 04 18

20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2704.18

~~counted 20~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:04:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DDOUBLER

Job Number: 31828

Part Number: D2911

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

SB 07/04/19 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-20

PTD

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

ST 235

7/5/759

20

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/08

Job Completion



07/05/08

20

6.1 Acid etch : Alkaline per QSI 005

m.p 07/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070420	6.1	Acid: Alodine per Dwg. Perm. Change 1				070420	070420

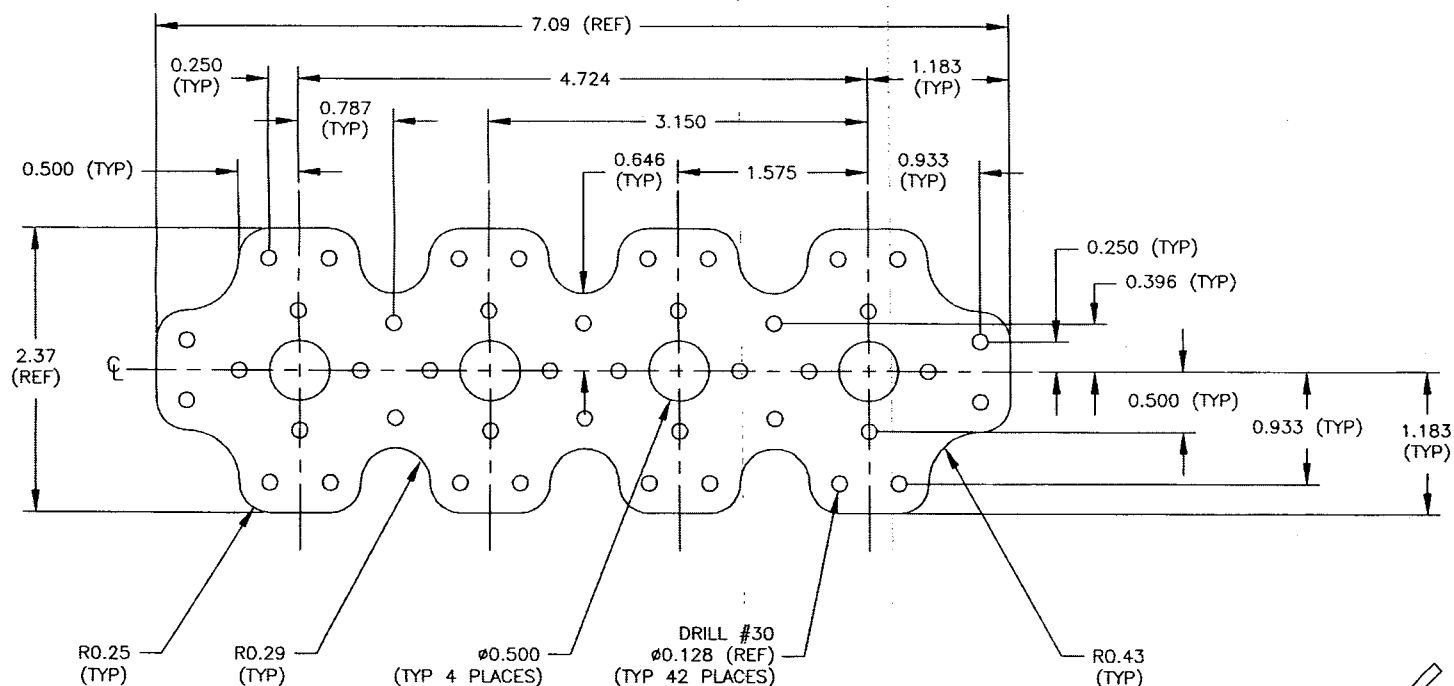
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
49-09-28 DS



FLAT PATTERN

BENDING DETAIL

R1.51

MATERIAL: 6061-T6 SHEET (QQ-A-250/11) 0.091" THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 008 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

NO. 31828
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

Copyright 1999 by DART AEROSPACE USA, INC.

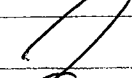
A	99.09.08	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	CP	APPROVED
DATE	99.09.08	TITLE DOUBLER
		DART DART AEROSPACE USA, INC. BELLEVUE, WA
		DRAWING NO. D2911
		REV. A SHEET 1 OF 1
		SCALE 1:1

DART AEROSPACE LTD		Work Order: 3828
Description: Doubler		Part Number: D2911
Inspection Dwg: D2911 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.37	+/- 0.030	2.374	✓		vern	
B 7.09	+/- 0.030					
C 4.724	+/- 0.010	4.726	✓		vern	
D 3.150	+/- 0.010	3.154	✓		vern	
E 1.575	+/- 0.010	1.575	✓		vern	
F 1.183	+/- 0.010	1.188	✓		vern	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml ml	Audited by: 	Prototype Approval:	N/A
Date: 070418	Date: 070418	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved



